



Dart Hawkesbury
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D4743-1
Job Sheet 167114



Part No: D4743-1

Job Qty: 100 ea

Part Name: Speaker Grill



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	100 Ea		11/9/17	0.00	0.00	Start up container	
110	Waterjet	100 pcs		11/9/17	0.00	9.35	Waterjet1	DAS 38
130	QC	100 pcs		11/9/17	0.00	0.00	QC8	38
140	Small Fab	100 pcs		11/9/17	0.00	2.73	Small Fab	9-89 DAS 38
150	QC	100 pcs		11/9/17	0.00	0.00	QC5	9-89 38
160	HandFinish	100 pcs		11/9/17	0.00	3.83	HandFinish1	2017-11-22 20
170	QC	100 pcs		11/9/17	0.00	0.00	QC7	BR 17-12-7
180	Powdercoat	100 pcs		11/10/17	0.00	0.67	Powdercoat4	BR 17-12-7
190	QC	100 pcs		11/10/17	0.00	0.00	QC3	BEB 17-12-7
200	Packaging	100 pcs		11/10/17	0.00	0.00	Packaging3	MFOOS 50
210	QC21-SA	100 Ea		11/10/17	0.00	0.00	QC21	

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - C'sink holes as per dwg

180 - POWDER COAT: Start Time: 3:50 Oven Temperature: 320° Finish Time: 4:20

M.135418.

DEC 12 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.080	20	95	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Speaker Grill	0.173Inches + 0.005 - 0.001	0.178 0.172	Diameter	
2	Speaker Grill	3.300Inches ± 0.030	3.330 3.270		
3	Speaker Grill	0.163Inches ± 0.010	0.173 0.153		
4	Speaker Grill	0.188Inches ± 0.010	0.198 0.178		
5	Speaker Grill	4.670Inches ± 0.030	4.700 4.640	Diameter	
6	Speaker Grill	5.300Inches ± 0.030	5.330 5.270	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation Start up Operation D4743-1 Operation: Revision: PART NO: Change No: Job No: 167114 Mfg Date: 11/09/17	Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pre. ☐ Ben. ☐ Cent ☐ Crack ☐ Crimp ☐ Cuffs ☐ Crush ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Examination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	OTHER : _____
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